



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3201-1

Job Sheet 179692



Part No: D3201-1

Job Qty: 6 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:A Removed from 9 Digit 06-01-25 JLM IPP Rev:B Now on Waterjet 06-08-14 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		7/18/18	0.00	0.00	Start Up Waterjet		SC 1807/04
100	Waterjet	6 pcs		7/18/18	0.00	0.23	Waterjet1		SC 1807/04
120	QC	6 pcs		7/18/18	0.00	0.00	QC8		38
140	HandFinish	6 pcs		7/18/18	0.00	0.22	HandFinish1		SA 1807-09
150	QC	6 pcs		7/18/18	0.00	0.00	QC7-2		38
160	Packaging	6 pcs		7/18/18	0.00	0.00	Packaging3	51023 89	JUL 13 2018
170	QC21-SA	6 Ea		7/18/18	0.00	0.00	QC21	53 9-89	JUL 16 2018

Part Op
Descriptions: 100 - 1-Cut as per Dwg D3201

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	1.6560 sf (.276 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	2	119	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.500inches ± 0.030	0.530 0.470	0, 509	
2	Doubler	3.570inches ± 0.030	3.600 3.540	3, 577	
3	Doubler	0.120inches ± 0.030	0.150 0.090	0, 125	
4	Doubler	8.000inches ± 0.030	8.030 7.970	8, 008	
5	Doubler	0.580inches ± 0.030	0.610 0.550	0, 589	
6	Doubler	4.890inches ± 0.030	4.920 4.860	4, 890	
7	Doubler	0.250inches ± 0.030	0.280	0, 254	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Suspected ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Forming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____		Step #: _____		12) Approval leted By d / Supervisor il Verification A Coordinator Approval Container No: S089822 Part: D3201-1 Job No: 179692 Serial No/ Batch: S089822 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/07/18				
Description Work Order Deviation								
Root Cause		tioned Wrong side Dimensions r/Under tolerance art Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence						
Environment	☐	No Re-verification	☐	Pressure	☐	Weld	☐	
Design	☐	Operator	☐	Bending	☐	Wrong Stock Pulled	☐	
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	Out of Sequence	☐	
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Off-set	☐	
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Mislabeled	☐	
Material	☐	Use for Testing	☐	Cuffs	☐	Fit/Function	☐	
Internal Transport	☐	Poor Information	☐	Crushing	☐	Misaligned/off center	☐	
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐			
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐			
Substation	☐	Process Improvement	☐	Marks/Chatter	☐			
Past Expiry Date	☐	Manufacturing Process	☐		☐			
Misidentified	☐	Past Due	☐	OTHER :	☐			

8	Doublor	0.040inches $\pm$ 0.010	0.220	0.050	0.030	g 040
---	---------	-------------------------	-------	-------	-------	-------

Plex 6/21/18 7:09 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					